

Date: Thursday, 3/8/2007 12:37:09 PM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
Job Number : 31105	
Estimate Number : 10258	
P.O. Number : N/A	Part Number : D2332041
This Issue : 3/8/2007 S.O. No. : N/A	Drawing Number : D2332 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 30547	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 4/5/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.03.08	
Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 K J/RF	

## **Additional Product**

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s)  
Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

M 103240

Batch

MF. 07-04-25

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)  
Material: Ø0.250" 304SS Rod

Batch M 11931

MF. 07-04-25

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

07/04/19 20  
07/03/30 20

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s)  
304 RD Tube .500 x .035W

M 102742  
M 103453

20  
20-58 07/03/20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

JB 07/03/20

(20)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M102756

FL

07/04/30

(20)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/30 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/30 (20)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

07/05/0 (20)

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M10291-

07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 07/05/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty	Part Number	Description
3	AN960JD416L	Washer

Batch

M/03962-

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description
1	MS21042L4	Nut (or -4)

Batch

M/03914-

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S5210

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

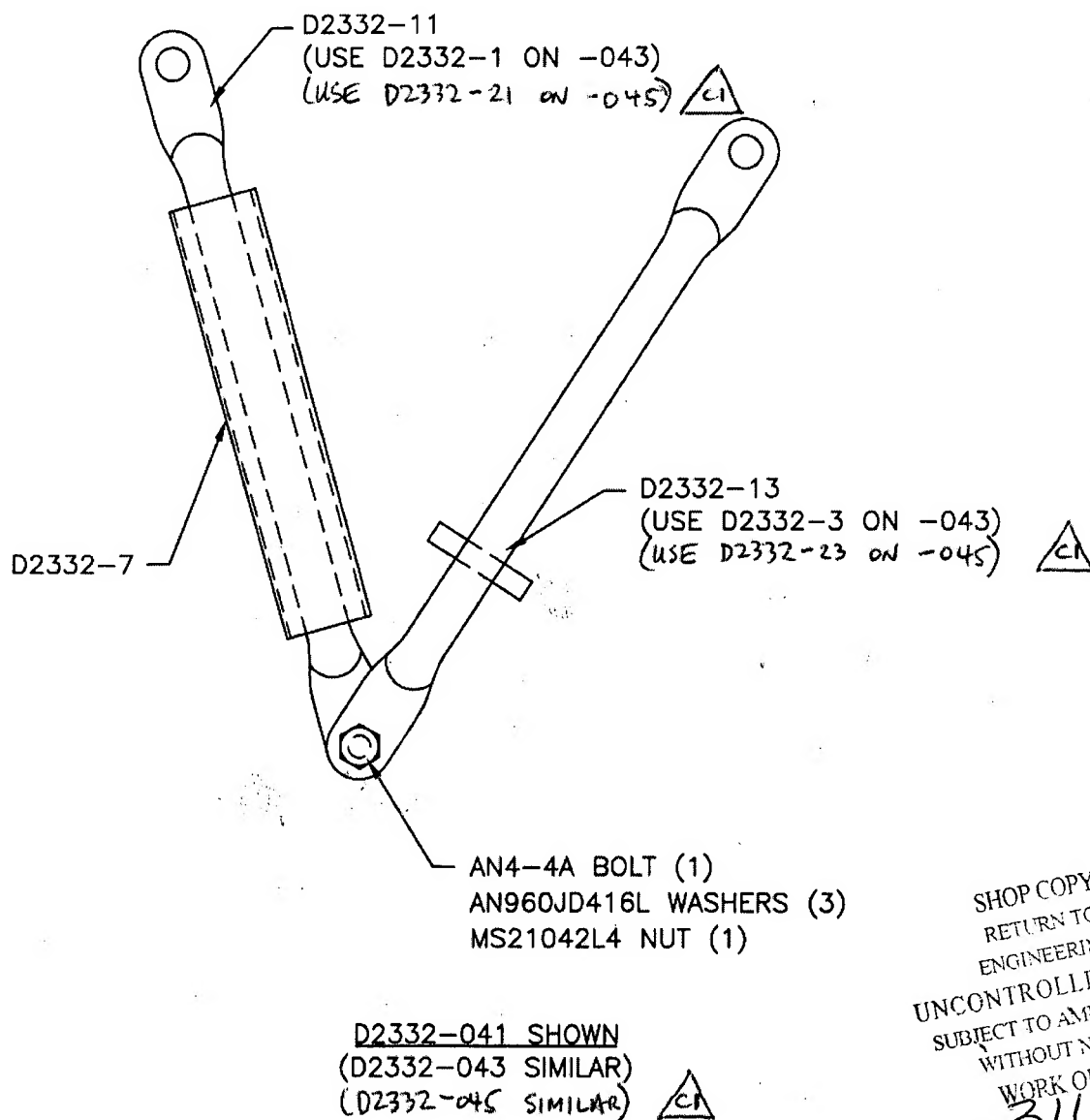
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED  
03.07.04



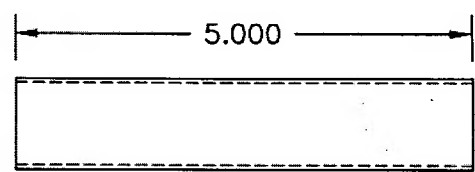
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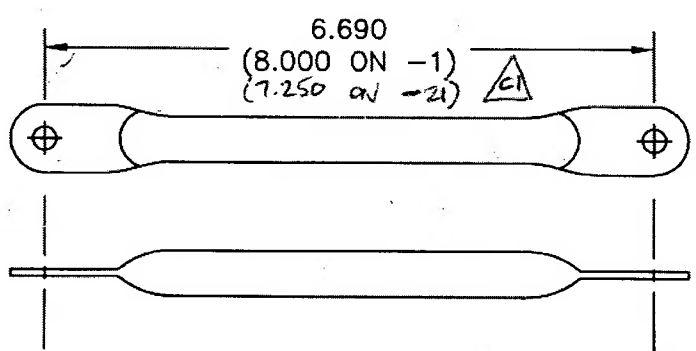
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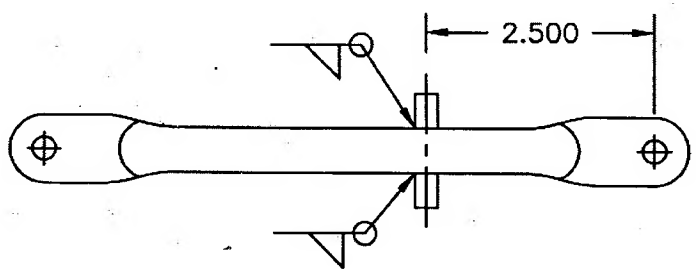
DESIGN	DRAWN BY	DART AEROSPACE LTD
03.07.03	03.07.03	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
03.07.03	03.08.06	D2332
DATE	TITLE	SHEET 2 OF 2
03.07.03	LID PROP ASSEMBLY	SCALE
		1:2



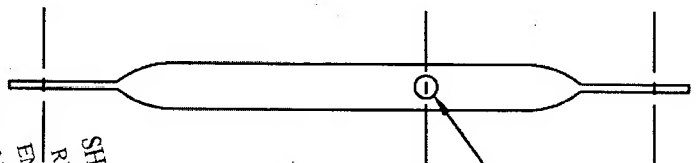
D2332-7 LOCKING COLLAR



D2332-11 PROP  
(D2332-1 SIMILAR)



D2332-5 STOP PIN



DRILL 1/4 HOLE FOR D2332-5

D2332-13  
M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED  
03.01.04

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